

20-835



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2893-1
Job Sheet 208082



Part No: D2893-1

Job Qty: 6 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/10/20

Job Tracking No:

Due Date: 4/20/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2893 REV D IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E
Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15
add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C ver:ECDWG /IPP Rev. I 19.10.01 New
issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	4/20/20		2.00	11.76	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	6 pcs	4/20/20		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



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CANADA
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Container No: S271154



Part: D2893-1

Job No: 208082

Serial No/Batch: S271154

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/17/22

				QC 8 - 76		
				QC 8 - 61		
130 Crosstubes - 2 - B4B	6 pcs	4/20/20	0.00 1.00	Crosstubes - 1 - B4B		
				Crosstubes - 2 - B4B		
				Crosstubes - 3 - B4B		DAS
				Crosstubes - 4 - B4B		41 APR 19 2020 9-89
140 QC 3	6 pcs	4/20/20	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
				QC 3 - 82		
						DAS 82 9-89 APR 20 2020
170 Packaging 3-1 - Stock - B4B	6 pcs	4/20/20	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		

180 QC 21 - SA	6 pcs	4/20/20	0.00	0.00	Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
					QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	DAS 21
					Broussard	APR 20 2020

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and use DT10660 apply 3M Scotch-Weld as per dwg. 5206999 exp 8/21

140 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	267642

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	3	12	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

Plex 3/10/20 1:57 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	208082
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.125	0.160	2.5 caliper	.150	.152	.150	.150	.140
AB	0.040	0.060		.052	.052	.050	.050	.047
AC	Ø0.260	Ø0.266		.262	.262	.261	.261	.265
AD	Ø0.187	Ø0.143		.188	.188	.188	.188	.185
AE	R0.240	R0.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.355	1.358		1.367	1.368
AG	1.200	1.240		1.203	1.203		1.208	1.210
AH	0.147	0.167		.155	.155		.160	.163
AI	2.985	3.005		2.987	2.987	2.996	2.998	2.998
AJ	0.400	0.500		.470	.470	.470	.470	.500
AK	4.930	4.990		4.962	4.962	4.962	4.963	4.963
AL	0.125	0.160		.140	.14	.140	.142	.160
AM	R0.053	R0.073		.063	.063	.063	.063	.063
AN	R0.240	R0.260		.250	.250	.250	.250	.250
AO	R0.021	R0.041		.032	.032	.031	.031	.030
AP	0.150	0.180		.170	.170	.173	.173	.160
AQ	R0.053	0.073		.063	.063		.063	.063
AR	2.302	2.322		2.322	2.322	2.322	2.322	2.313
AS	0.140	0.160		.154	.147		.147	.150
AT	0.040	0.060		.054	.053	.053	.051	.052
Accept/Reject								

Measured by: DE Date: 10/4/18

Audited by: MP Date: 10/4/18

Preliminary Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG	MP

DART AEROSPACE LTD		Work Order:	208082
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
HAAS Section								
AA	0.125	0.160		.147	.140	.148	.133	.142
AB	0.040	0.060		.047	.048	.049	.051	.047
AC	Ø0.260	Ø0.266		.261	.261	.261	.261	.261
AD	Ø0.187	Ø0.143		.188	.188	.188	.188	.188
AE	0.240	0.250		.252	.250	.250	.250	.250
AF	1.347	1.407		1.371	1.372	1.373	1.369	1.372
AG	1.200	1.240		1.208	1.206	1.216	1.208	1.207
AH	0.147	0.167		.162	.164	.163	.162	.162
AI	2.985	3.005		2.998	3.000	2.997	3.000	2.998
AJ	0.400	0.500		.500	.500	.500	.500	.500
AK	4.930	4.990		4.963	4.963	4.963	4.963	4.963
AL	0.125	0.160		.135	.141	.141	.141	.143
AM	R0.053	R0.073		.063	.063	.063	.063	.063
AN	R0.240	R0.260		.250	.250	.250	.250	.250
AO	R0.021	R0.041		.031	.031	.031	.031	.031
AP	0.150	0.180		.170	.172	.160	.160	.172
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	2.302	2.322		2.316	2.313	2.322	2.313	2.317
AS	0.140	0.160		.150	.148	.148	.148	.146
AT	0.040	0.060		.055	.051	.056	.051	.047
Accept/Reject								

Measured by:	zmc	Date:	20/01/15
Audited by:	UAS	Date:	20/04/15
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
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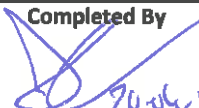
Entered:



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8350

Route update only

Job: <u>208082</u>		DISPOSITION		DEPARTMENT/PROCESS							
Part No. <u>D2893-1</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>20/04/12</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>				MRB (QSI042)			
Description Work Order Deviation				Disposition				AD 20-06-02			
Part are Damaged He had a line at the wrong place for a tool retract. He plunge in the part.				SCRAP and destroy				Completed By			
								 20-04-13			
								Lead hand / Supervisor			
								QC / QA Coordinator			
								AD 2006-02			
Root Cause		FAULT CATEGORY									
Operator ☒		☐ Pressure/Forced		☐ Contamination		☐ Power Loss/Surge		☐ Positioned Wrong			
Manufacturing Process ☐		☐ Bending		☐ Misaligned/off center		☐ Folio/Program		☐ Outside Tolerance			
Equip/Tooling ☐		☐ Crushing		☐ BOM/Route		☐ Grain Direction		☐ Drawing			
Handling/Preservation ☐		☐ Cracks		☒ Broken/Damage/Defect		☐ Weld		☐ Finish			
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Wrong Stock Pulled		☐ Part Lost/Missing			
Product Improvement ☐		☐ Marks/Chatter		☐ Drill Holes		☐ Out of Sequence		☐ Misread			
Process Improvement ☐		☐ Mislabeled		☐ Fit/Function		☐ Off-set/Set-up					
Human Factors ☐		Other/Details:									